

Date: Monday, 14/11/2005 3:41:03 PM
User: Alba Panzuto

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 24433
Estimate Number : 10530
P.O. Number : N/A Part Number : D2571
This Issue : 14/11/2005 S.O. No. : N/A Drawing Number : D2571 REV D
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
Previous Run : N/A Material : N/A
Written By : SEE COMMENT BELOW Due Date : 30/11/2005 Qty: 8 Um: Each
Checked & Approved By : SEE COMMENT BELOW
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 24433 Double check by: J.L

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets MS 06/01/26
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets MS 06/01/26
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets MS 06/01/26
4-Deburr and remove all machining marks MS 06/01/26
5-Tumble to remove sharp edges. N/A

S.G 06/01/28 8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

S.G 06/01/28 8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.G 06/01/28 8

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

B6 06.01.29 8

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Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 24433

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MM 06 01 30

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MM 06 01 30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CD 06/01/31 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *372*

C 206/01/31 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUC 06/02/01 (8) *DP* 06/02/01

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:09 pm

Work Order No : 0024433
Project Name : D2571/72
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2571
Description : Saddle, Fwd, Out
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 10-05-05
Est Finish Date : 11-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

MIS 0/B
11.15

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.749	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.750	1.749	1.749		
E	7.990	8.010		8.002	8.003	8.003	8.002		
F	0.490	0.510		0.501	0.500	0.500	0.501		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.499	0.499	0.499	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.568	0.568	0.568		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.496	1.497	1.497		
N	2.495	2.505		2.501	2.500	2.501	2.500		
O	3.869	3.879		3.873	3.872	3.873	3.874		
P	0.115	0.135		0.123	0.122	0.121	0.121		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.251	0.251		
S	0.115	0.135		0.121	0.120	0.121	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.962	2.962	2.961		
V	0.230	0.250		0.235	0.236	0.236	0.236		
W	0.115	0.135		0.117	0.118	0.119	0.119		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.362	0.363	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.630	0.631	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.253	0.253	0.252		
AE	1.375	1.395		1.384	1.383	1.383	1.382		
AF	0.115	0.135		0.134	0.135	0.134	0.135		
AG	0.240	0.280		0.265	0.264	0.264	0.265		
AH	0.240	0.260		0.245	0.246	0.247	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<u>S.G.</u>
Date:	<u>06/01/28</u>

Audited by:	<u>BC</u>
Date:	<u>06.01.29</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
11/05/2028

DART AEROSPACE LTD	Work Order:	
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Inspection Dwg: D2571 Rev. E		Page 1 of 1

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P	0.115	0.135		0.122	0.122	0.121	0.121		
Q	0.115	0.135		0.130	0.131	0.130	0.131		
R	0.240	0.260		0.246	0.245	0.245	0.246		
S	0.115	0.135		0.120	0.121	0.120	0.119		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.960	2.961	2.960		
V	0.230	0.250		0.240	0.240	0.240	0.241		
W	0.115	0.135		0.118	0.118	0.118	0.119		
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AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G
Date:	06/01/29

Audited by:	RG
Date:	06.01.29

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